

Date: Friday, 7/4/2008 8:47:52 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE KIT FOR D206-642-511
Job Number : 40258	
Estimate Number : 12893	
P.O. Number :	Part Number : K642 511
This Issue : 7/4/2008 S.O. No. :	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SKIDTUBES	Drawing Revision : N/A
Previous Run : 37360	Material :
Written By :	Due Date : 7/22/2008 Qty: 2 Um: Each
Checked & Approved By : <u>080704</u>	
Comment : Est Rev.A 07.06.05 new issue EC Est Rev.B 08.02.05 , Per ECN1080P LL	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP K642-511 CHG003

N/A JUD 08.7.18

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D206648013	GHW Modification
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

GHW Kit

Batch: 37418

SP

4.0	D2652	Bushing
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
16 D2652	Bushing	<u>39220</u>

SP

5.0	D2712	Set Screw
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Comment: Qty.: 10.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
10 D2712	Set Screw	<u>37765</u>

8/7/7

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Machine Or Operation:

Description :

6.0

D29321

Saddle LH Out, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2932-1

Saddle

39771

39887

SP

7.0

D29331

Saddle LH In, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2933-1

Saddle

39773

39888

SP

8.0

D2934

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2934

Saddle Spacer

39688

SP

9.0

D2935

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2935

Saddle Spacer

B37867

50
B40282

8/7/16

SP

10.0

D29381

Saddle LH Out, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2938-1

Saddle

34631

SP

11.0

D29391

Saddle LH In, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2939-1

Saddle

36143

39776

8/7/17

SP

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D33963

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3396-3

Spacer

56336

SP

13.0

D3407043

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3407-043

Tow Ring

37372

SP

14.0

D34561

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3456-1

Washer

B40295

8/7/10

SP

15.0

D34571

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3457-1

Washer

37123

SP

16.0

AN3C35A

BOLT



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description Batch

3 AN3C35A

Bolt

107463

SP

17.0

AN3C36A

BOLT



Comment: Qty.: 9.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number

Description Batch

9 AN3C36A

Bolt

106541

8/7/10

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 40258

Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN3C41A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN3C41A

Bolt

108084

SP

19.0

AN4C6A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 AN4C6A

Bolt

106519

SP

20.0

AN5C11A



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN5C11A

Bolt

108428

SP

21.0

AN5C12A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN5C12A

Bolt

1107328

SP

22.0

AN5C13A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN5C13A

Bolt

107615

SP

23.0

AN5C15A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C15A

Bolt

101291 105125 8/7/7

(2x)

SB

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 40258

Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN5C32A



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C32A

Bolt

107013

SD

25.0

AN5C34A



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C34A

Bolt

107289

SD

26.0

AN5C35A



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C35A

Bolt

107551

SD

27.0

AN960C10L

washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960C10L

Washer

107971

108246

SD

28.0

AN960C416L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960C416L

Washer

107650

107008

8/7/7

SD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 40258

Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

AN960C516L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN960C516L

Washer

103344

SP

30.0

MS210433

Nut



Comment: Qty.: 20.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

20 MS21043-3

Nut

108161

SP

31.0

MS210434

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 26.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

13 MS21043-4

Nut

107285

108148

SP

32.0

MS210435

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 MS21043-5Nut

107285

106763

SP

33.0

D36721

Phenolic Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

PHENOLIC WASHER

B39275

SP

34.0

D36723

Phenolic Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

PHENOLIC WASHER

B37374

8/1/7

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 40258

Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

D36725

Phenolic Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

PHENOLIC WASHER

B 35521

SP

36.0

D36727

Phenolic Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

PHENOLIC WASHER

B 35522
8/7/7

(2x)

SP

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/07/16 (R)

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP K642-511 CHG003

Location: ST PKg.

08/07/16 (R)

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/18

Job Completion



MF 08-07-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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